

Date: Friday, 11/18/2005 5:39:38 PM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE BILLET
Job Number : 24890	
Estimate Number : 10032	
P.O. Number : <i>N/A</i>	Part Number : D6101001
This Issue : 11/18/2005 S.O. No. : <i>N/A</i>	Drawing Number : D6101 REV A
Prsht Rev. : NC	Project Number : <i>N/A</i>
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 23934	Material : <i>N/A</i>
Written By : <i>See Comment below</i>	Due Date : 12/20/2005 Qty: 100 Um: Each
Checked & Approved By : <i>See Comment below</i>	
Comment : Est. B: 01.05.04 New Issue EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: *154*

a) Description: Alluminum billet

b) 6.00" x 6.250" x 2.00" thick

c) Tolerance on length are +0.025"/-0.000" AE +/-0.008"

d) Grain direction along 6.00" length

e) Material: 7075-T7351 (QQ-A-250/12)

f) Material certification required

*u**05.11.23*

2.0

D6101001

7075-T7351 2X6X6.25



Comment: Qty.: 1.0000 Each(s)/Unit Total: 100.0000 Each(s)  
 7075-T7351 2X6X6.25

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure material certification is attached

*CL 05/12/22**100*

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D

*ED 06/01/03**100*

W/O: WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/01/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BILLET

Job Number: 24890

Part Number: D6101001

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*EP 06/01/03*

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*SUR 06/01/05*

*(100) KSD 06/01/04 (100)*

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Nov 18, 2005  
09:21 am

Work Order No	: 0024890	Department Code:	
Project Name	: D6101-001	Burden Flags	: NNNNNNNN
Project For	: WK602	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D6101-001	Invoice Number	:
Description	: 7075-T7351 2X6X6.25	Invoice Amount	: 0.00
Manufactured	: Yes		
Amount Req'd	: 100	Order Entry No	:
Amount Done	: 0	OE Value	: 0.00
Start Date	: 11-18-05		
Est Finish Date	: 01-15-06	Est Margin	: 0.000%
Act Finish Date	:	Actual Margin	: 0.000%
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:	\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
=====					
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
=====					
Burden	: 0.00	0.00	0.00		
=====					
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00



40 Skyline Drive, Plainview, NY 11803 Tel: 516.822.8300 Fax: 516.822.8332

Customer PO #	Order Date	SP
00000154	11/23/05	JP

Sales Order Number	5465
Invoice Date	12/21/2005
Invoice Number	27657

Ship To:

DART AEROSPACE LTD.  
1270 ABERDEEN STREET  
HAWKESBURY, ON K6A 1K7  
CANADA

# Pkg.	4 SKIDS
Weight	4590 LBS

Terms	Ship Date	Shipped Via	Freight	FOB	Test Reports
50% CIA/BAL N...	12/21/2005	THROWBRIDGE ...	COLLECT	ORIGIN	Y

Item No.	Orig. Qty	Unit	Description	Bal. on Order	Qty This Shipment
1	100	EA	7075-T7351 QQ-A-250/12 6.00" X 6.25" X 2.00" THK ✓ (GRAIN ALONG 6" DIM)		100
2	100	EA	7075-T7351 QQ-A-250/12 7.875" X 6.25" X 2.00" THK. (GRAIN ALONG 7.875 DIM)		100
3	100	EA	7075-T7351 QQ-A-250/12 5.00" X 6.25" X 2.50" THK (GRAIN ALONG 5" DIM)		100
4	100	EA	7075-T7351 QQ-A-250/12 7.75" X 8.25" X 2.50" THK (GRAIN ALONG 7.75" DIM)		100
			CUT TOLERANCE ON ALL IS +.063/-00		

PACKING LIST

CERTIFICATE OF COMPLIANCE

We certify that the materials described above conform to the specifications stated.

*Cathie Vail*  
Quality Control Manager



1, Zavodskaya Str.  
347045 Belaya Kalitva  
Rostov region Russia

OAO «Belaya Kalitva Metallurgical Products Company»

INSPECTION CERTIFICATE

EN 10204-3.1B

No 5754  
Date 23.06.05

CUSTOMER

Alcoa-Köfem Kft.  
Veszeci u. 1-15  
Szekesfehervar  
HU- 8000  
Hungary

CONTRACT № 643/54044146/002

APPENDIX № 12721

ORDER №

Description of Goods Aluminium Plates

Alloy and Temper 7075 T 651

Lot № 70461

Standard ASTM B209-02a, ANSI -H35.2-01, AMS-QQ-A-250/12,  
AMS 4045H

Dimension 2,0300\*60,500\*144,500

Net Weight 1702 kg Qt. of packages \_\_\_\_\_ pcs

CONSIGNEE

DIVERSIFIED INDUSTRIAL PROD.  
40 SKYLINE DRIVE  
PLAINVIEW, N.Y.11803

MECHANICAL PROPERTIES		Ultimate Strength	Yield Strength	Elongation
Units		KSI	KSI	Rlt %
Nominal requirements	min	76,0	64,0	5
	max			
Test results		77,9-78,8	68,1-68,9	8,8-10,4

DIVERSIFIED INDUSTRIAL PRODUCTS CORP.  
CERTIFY THIS A TRUE COPY OF THE  
MILL TEST REPORT USED TO FILL YOUR  
ORDER.

Company

PO#

Our Inv. #

Qty.

Part #

QC Dept.

DART AEROSPACE LTD.

00000154

27657

100 EA

Cathie Vail

Cathie Vail

ITEM # 1  
\* STARTING  
MATERIAL \*



©opma OIT.058/01

CHEMICAL COMPOSITION, %

		Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Ti
Nominal requirements	min			1,2		2,1	0,18		5,1	
	max	0,40	0,50	2,0	0,3	2,9	0,28		6,1	0,2
Test results										
Cont №	4-994	0,10	0,31	1,62	0,09	2,48	0,21		5,85	0,055

It is hereby certified that the above material is manufactured in  
compliance with the specified standards and meets the stipulated requirements

Quality Control Inspector

00 Rebr

0911 9

001

001 JUL 8

60%

Company

0911 1911

ORDER

MILL TEST REPORT USED TO FILL YOUR  
CERTIFY THIS A TRUE COPY OF THE  
DIVERSIFIED INDUSTRIAL PRODUCTS CORP.



# Burton Industries, Inc.

243 Wyandanch Avenue North Babylon, NY 11704 (631) 643-6660 FAX (631) 643-6665

Serving the Heat Treating Industry since 1971

## Certificate of Compliance

**Diversified Industrial Prod. Corp.**

**40 Skyline Drive**

**Plainview, NY 11803**

**(516) 822 - 8300 FAX (516) 822 - 8332**

**Ref. No: 129817**

**Issued: 12/20/2005**

<b>Material: 7075-T651</b>		<b>Cond. Req'd. T7351</b>		<b>Spec.</b>		
<b>Quantity</b>	<b>Part Number</b>			<b>Purchase Order</b>		
100	6.00 X 6.25 X 2.00" THK			22475		
100	7.875 X 6.25 X 2.00" THK					
100	5.00 X 6.25 X 2.50" THK					
100	7.75 X 8.25 X 2.50" THK					

<b>Process Performed</b>		<b>Date</b>	<b>Temp ( F)</b>	<b>Time</b>	<b>Atmosphere</b>	<b>Furnace</b>	<b>Hardness</b>
ARTIFICIAL AGE		12/17/2005	325	26 HRS	AIR	260	
HRB							80-83

<b>Condition</b>	<b>T7351</b>	<b>Tested</b>	<b>40</b>	<b>Passed</b>	<b>40</b>	<b>Reject</b>	<b>0</b>
<b>Conductivity</b>	<b>39.5-41.1 % IACS</b>	<b>Tested</b>	<b>400</b>	<b>Passed</b>	<b>400</b>	<b>Reject</b>	<b>0</b>

We hereby certify that the articles stipulated above have been processed in conformance with all applicable specifications, drawings, and/or written instructions. Test and/or Inspection Reports indicating conformance are on file for examination

*Nancy Mase*



Nancy Mase

Q.A. Administrator

Burton Industries, Inc.



"Building a Stronger Future"

<http://www.heatreat.com>

AS 9100A Compliant



V050405R2A 129806